

# INTERNET COOPERATION TREATY

**PCT**

## NOTIFICATION OF ELECTION

(PCT Rule 61.2)

From the INTERNATIONAL BUREAU

To:

Commissioner  
US Department of Commerce  
United States Patent and Trademark  
Office, PCT  
2011 South Clark Place Room  
CP2/5C24  
Arlington, VA 22202  
ETATS-UNIS D'AMERIQUE  
in its capacity as elected Office

Date of mailing: 22 March 2001 (22.03.01)	
International application No.: PCT/AU00/01002	Applicant's or agent's file reference:
International filing date: 24 August 2000 (24.08.00)	Priority date: 16 September 1999 (16.09.99)
Applicant: WILSON, Graham, Louis	

1. The designated Office is hereby notified of its election made:

☒ in the demand filed with the International preliminary Examining Authority on:  
25 January 2001 (25.01.01)

☐ in a notice effecting later election filed with the International Bureau on:

2. The election ☒ was

☐ was not

made before the expiration of 19 months from the priority date or, where Rule 32 applies, within the time limit under Rule 32.2(b).

The International Bureau of WIPO 34, chemin des Colombettes 1211 Geneva 20, Switzerland Facsimile No.: (41-22) 740.14.35	Authorized officer:  J. Zahra Telephone No.: (41-22) 338.83.38
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## PATENT COOPERATION TREATY

PCT

From the INTERNATIONAL BUREAU

NOTIFICATION OF RECEIPT OF  
RECORD COPY

(PCT Rule 24.2(a))

To:

GRANT, Paul, Ainsworth  
P.O. Box 60  
Fisher, ACT 2611  
AUSTRALIE

Date of mailing (day/month/year) 12 October 2000 (12.10.00)	IMPORTANT NOTIFICATION
Applicant's or agent's file reference	International application No. PCT/AU00/01002

The applicant is hereby notified that the International Bureau has received the record copy of the international application as detailed below.

Name(s) of the applicant(s) and State(s) for which they are applicants:

HOTFLO DIECASTING PTY LTD (for all designated States except US)  
WILSON, Graham, Louis (for US)

International filing date : 24 August 2000 (24.08.00)  
Priority date(s) claimed : 16 September 1999 (16.09.99)  
Date of receipt of the record copy  
by the International Bureau : 11 September 2000 (11.09.00)

List of designated Offices :

AP : GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW  
EA : AM, AZ, BY, KG, KZ, MD, RU, TJ, TM  
EP : AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE  
OA : BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG  
National : AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CR, CU, CZ, DE, DK, DM, DZ, EE,  
ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA,  
MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US,  
UZ, VN, YU, ZA, ZW

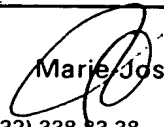
## ATTENTION

The applicant should carefully check the data appearing in this Notification. In case of any discrepancy between these data and the indications in the international application, the applicant should immediately inform the International Bureau.

In addition, the applicant's attention is drawn to the information contained in the Annex, relating to:

- ☒ time limits for entry into the national phase  
☐ confirmation of precautionary designations  
☒ requirements regarding priority documents

A copy of this Notification is being sent to the receiving Office and to the International Searching Authority.

The International Bureau of WIPO 34, chemin des Colombettes 1211 Geneva 20, Switzerland	Authorized officer:  Marie José Devillard
Facsimile No. (41-22) 740.14.35	Telephone No. (41-22) 338.83.38

# PATENT COOPERATION TREATY

**PCT**

## NOTICE INFORMING THE APPLICANT OF THE COMMUNICATION OF THE INTERNATIONAL APPLICATION TO THE DESIGNATED OFFICES

(PCT Rule 47.1(c), first sentence)

From the INTERNATIONAL BUREAU

To:

GRANT, Paul, Ainsworth  
P.O. Box 60  
Fisher, ACT 2611  
AUSTRALIE

Date of mailing (day/month/year) 22 March 2001 (22.03.01)		
Applicant's or agent's file reference		<b>IMPORTANT NOTICE</b>
International application No. PCT/AU00/01002	International filing date (day/month/year) 24 August 2000 (24.08.00)	
		Priority date (day/month/year) 16 September 1999 (16.09.99)
Applicant HOTFLO DIECASTING PTY LTD et al		

1. Notice is hereby given that the International Bureau has communicated, as provided in Article 20, the international application to the following designated Offices on the date indicated above as the date of mailing of this Notice:  
**AU, KP, KR, US**

In accordance with Rule 47.1(c), third sentence, those Offices will accept the present Notice as conclusive evidence that the communication of the international application has duly taken place on the date of mailing indicated above and no copy of the international application is required to be furnished by the applicant to the designated Office(s).

2. The following designated Offices have waived the requirement for such a communication at this time:

**AE, AG, AL, AM, AP, AT, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CR, CU, CZ, DE, DK, DM, DZ, EA, EE, EP, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, OA, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, UZ, VN, YU,**  
The communication will be made to those Offices only upon their request. Furthermore, those Offices do not require the applicant to furnish a copy of the international application (Rule 49.1(a-bis)).

3. Enclosed with this Notice is a copy of the international application as published by the International Bureau on 22 March 2001 (22.03.01) under No. WO 01/19552

### REMINDER REGARDING CHAPTER II (Article 31(2)(a) and Rule 54.2)

If the applicant wishes to postpone entry into the national phase until 30 months (or later in some Offices) from the priority date, a **demand for international preliminary examination** must be filed with the competent International Preliminary Examining Authority before the expiration of 19 months from the priority date.

It is the applicant's sole responsibility to monitor the 19-month time limit.

Note that only an applicant who is a national or resident of a PCT Contracting State which is bound by Chapter II has the right to file a demand for international preliminary examination.

### REMINDER REGARDING ENTRY INTO THE NATIONAL PHASE (Article 22 or 39(1))

If the applicant wishes to proceed with the international application in the **national phase**, he must, within 20 months or 30 months, or later in some Offices, perform the acts referred to therein before each designated or elected Office.

For further important information on the time limits and acts to be performed for entering the national phase, see the Annex to Form PCT/IB/301 (Notification of Receipt of Record Copy) and Volume II of the PCT Applicant's Guide.

<p>The International Bureau of WIPO 34, chemin des Colombettes 1211 Geneva 20, Switzerland</p> <p>Facsimile No. (41-22) 740.14.35</p>	<p>Authorized officer  J. Zahra</p> <p>Telephone No. (41-22) 338.83.38</p>
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## PATENT COOPERATION TREATY

PCT

From the INTERNATIONAL BUREAU

NOTIFICATION CONCERNING  
SUBMISSION OR TRANSMITTAL  
OF PRIORITY DOCUMENT

(PCT Administrative Instructions, Section 411)

To:

GRANT, Paul, Ainsworth  
P.O. Box 60  
Fisher, ACT 2611  
AUSTRALIE

Date of mailing (day/month/year) 30 October 2000 (30.10.00)	
Applicant's or agent's file reference	<b>IMPORTANT NOTIFICATION</b>
International application No. PCT/AU00/01002	International filing date (day/month/year) 24 August 2000 (24.08.00)
International publication date (day/month/year) Not yet published	Priority date (day/month/year) 16 September 1999 (16.09.99)
Applicant HOTFLO DIECASTING PTY LTD et al	

1. The applicant is hereby notified of the date of receipt (except where the letters "NR" appear in the right-hand column) by the International Bureau of the priority document(s) relating to the earlier application(s) indicated below. Unless otherwise indicated by an asterisk appearing next to a date of receipt, or by the letters "NR", in the right-hand column, the priority document concerned was submitted or transmitted to the International Bureau in compliance with Rule 17.1(a) or (b).
2. This updates and replaces any previously issued notification concerning submission or transmittal of priority documents.
3. An asterisk(\*) appearing next to a date of receipt, in the right-hand column, denotes a priority document submitted or transmitted to the International Bureau but not in compliance with Rule 17.1(a) or (b). In such a case, **the attention of the applicant is directed** to Rule 17.1(c) which provides that no designated Office may disregard the priority claim concerned before giving the applicant an opportunity, upon entry into the national phase, to furnish the priority document within a time limit which is reasonable under the circumstances.
4. The letters "NR" appearing in the right-hand column denote a priority document which was not received by the International Bureau or which the applicant did not request the receiving Office to prepare and transmit to the International Bureau, as provided by Rule 17.1(a) or (b), respectively. In such a case, **the attention of the applicant is directed** to Rule 17.1(c) which provides that no designated Office may disregard the priority claim concerned before giving the applicant an opportunity, upon entry into the national phase, to furnish the priority document within a time limit which is reasonable under the circumstances.

<u>Priority date</u>	<u>Priority application No.</u>	<u>Country or regional Office or PCT receiving Office</u>	<u>Date of receipt of priority document</u>
16 Sept-1999 (16.09.99)	PQ2907	AU	14 Sept 2000 (14.09.00)

The International Bureau of WIPO  
34, chemin des Colombettes  
1211 Geneva 20, Switzerland

Facsimile No. (41-22) 740.14.35

Authorized officer

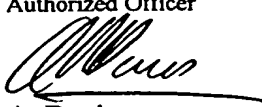
Marie-José Devillard

Telephone No. (41-22) 338.83.38

**PATENT COOPERATION TREATY**  
**PCT**  
**INTERNATIONAL PRELIMINARY EXAMINATION REPORT**  
(PCT Article 36 and Rule 70)

Applicant's or agent's file reference	<b>FOR FURTHER ACTION</b>	See Notification of Transmittal of International Preliminary Examination Report (Form PCT/IPEA/416).
International Application No. <b>PCT/AU00/01002</b>	International Filing Date ( <i>day/month/year</i> ) <b>24 August 2000</b>	Priority Date ( <i>day/month/year</i> ) <b>16 September 1999</b>
International Patent Classification (IPC) or national classification and IPC  <b>Int. Cl. <sup>7</sup> B22D 17/02, 17/30, 35/04, 35/06</b>		
Applicant  <b>HOTFLO DIECASTING PTY LTD et al</b>		

1.	This international preliminary examination report has been prepared by this International Preliminary Examining Authority and is transmitted to the applicant according to Article 36.																								
2.	This REPORT consists of a total of <b>3</b> sheets, including this cover sheet.  <input type="checkbox"/> This report is also accompanied by ANNEXES, i.e., sheets of the description, claims and/or drawings which have been amended and are the basis for this report and/or sheets containing rectifications made before this Authority (see Rule 70.16 and Section 607 of the Administrative Instructions under the PCT).  These annexes consist of a total of     sheet(s).																								
3. This report contains indications relating to the following items: <table style="width: 100%; margin-top: 10px;"> <tr> <td style="width: 5%;">I</td> <td style="width: 5%; text-align: center;"><input checked="" type="checkbox"/></td> <td>Basis of the report</td> </tr> <tr> <td>II</td> <td style="text-align: center;"><input type="checkbox"/></td> <td>Priority</td> </tr> <tr> <td>III</td> <td style="text-align: center;"><input checked="" type="checkbox"/></td> <td>Non-establishment of opinion with regard to novelty, inventive step and industrial applicability</td> </tr> <tr> <td>IV</td> <td style="text-align: center;"><input type="checkbox"/></td> <td>Lack of unity of invention</td> </tr> <tr> <td>V</td> <td style="text-align: center;"><input checked="" type="checkbox"/></td> <td>Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement</td> </tr> <tr> <td>VI</td> <td style="text-align: center;"><input type="checkbox"/></td> <td>Certain documents cited</td> </tr> <tr> <td>VII</td> <td style="text-align: center;"><input type="checkbox"/></td> <td>Certain defects in the international application</td> </tr> <tr> <td>VIII</td> <td style="text-align: center;"><input type="checkbox"/></td> <td>Certain observations on the international application</td> </tr> </table>		I	<input checked="" type="checkbox"/>	Basis of the report	II	<input type="checkbox"/>	Priority	III	<input checked="" type="checkbox"/>	Non-establishment of opinion with regard to novelty, inventive step and industrial applicability	IV	<input type="checkbox"/>	Lack of unity of invention	V	<input checked="" type="checkbox"/>	Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement	VI	<input type="checkbox"/>	Certain documents cited	VII	<input type="checkbox"/>	Certain defects in the international application	VIII	<input type="checkbox"/>	Certain observations on the international application
I	<input checked="" type="checkbox"/>	Basis of the report																							
II	<input type="checkbox"/>	Priority																							
III	<input checked="" type="checkbox"/>	Non-establishment of opinion with regard to novelty, inventive step and industrial applicability																							
IV	<input type="checkbox"/>	Lack of unity of invention																							
V	<input checked="" type="checkbox"/>	Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement																							
VI	<input type="checkbox"/>	Certain documents cited																							
VII	<input type="checkbox"/>	Certain defects in the international application																							
VIII	<input type="checkbox"/>	Certain observations on the international application																							

Date of submission of the demand <b>25 January 2001</b>	Date of completion of the report <b>2 February 2001</b>
Name and mailing address of the IPEA/AU <b>AUSTRALIAN PATENT OFFICE</b> <b>PO BOX 200, WODEN ACT 2606, AUSTRALIA</b> E-mail address: <b>pct@ipaaustralia.gov.au</b> Facsimile No. <b>(02) 6285 3929</b>	Authorized Officer  <b>A. Davies</b> Telephone No. <b>(02) 6283 2072</b>

**I. Basis of the report****1. With regard to the elements of the international application:\***

- ☒ the international application as originally filed.
- ☐ the description,      pages , as originally filed,  
   pages , filed with the demand,  
   pages , received on      with the letter of
- ☐ the claims,      pages , as originally filed,  
   pages , as amended (together with any statement) under Article 19,  
   pages , filed with the demand,  
   pages , received on      with the letter of
- ☐ the drawings,      pages , as originally filed,  
   pages , filed with the demand,  
   pages , received on      with the letter of
- ☐ the sequence listing part of the description:  
   pages , as originally filed  
   pages , filed with the demand  
   pages , received on      with the letter of

**2. With regard to the language, all the elements marked above were available or furnished to this Authority in the language in which the international application was filed, unless otherwise indicated under this item.**

These elements were available or furnished to this Authority in the following language which is:

- ☐ the language of a translation furnished for the purposes of international search (under Rule 23.1(b)).
- ☐ the language of publication of the international application (under Rule 48.3(b)).
- ☐ the language of the translation furnished for the purposes of international preliminary examination (under Rules 55.2 and/or 55.3).

**3. With regard to any nucleotide and/or amino acid sequence disclosed in the international application, was on the basis of the sequence listing:**

- ☐ contained in the international application in written form.
- ☐ filed together with the international application in computer readable form.
- ☐ furnished subsequently to this Authority in written form.
- ☐ furnished subsequently to this Authority in computer readable form.
- ☐ The statement that the subsequently furnished written sequence listing does not go beyond the disclosure in the international application as filed has been furnished.
- ☐ The statement that the information recorded in computer readable form is identical to the written sequence listing has been furnished

**4. ☐ The amendments have resulted in the cancellation of:**

- ☐ the description,      pages
- ☐ the claims,      Nos.
- ☐ the drawings,      sheets/fig.

**5. ☐ This report has been established as if (some of) the amendments had not been made, since they have been considered to go beyond the disclosure as filed, as indicated in the Supplemental Box (Rule 70.2(c)).\*\***

\* Replacement sheets which have been furnished to the receiving Office in response to an invitation under Article 14 are referred to in this report as "originally filed" and are not annexed to this report since they do not contain amendments (Rules 70.16 and 70.17).

\*\* Any replacement sheet containing such amendments must be referred to under item 1 and annexed to this report

**V. Reasoned statement under Article 35(2) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement****1. Statement**

Novelty (N)	Claims 1-20	YES
	Claims	NO
Inventive step (IS)	Claims 1-20	YES
	Claims	NO
Industrial applicability (IA)	Claims 1-20	YES
	Claims	NO

**2. Citations and explanations (Rule 70.7)**

US, 5315686, A (CAUGHERTY et al) 24 May 1994

US, 5203397, A (BANDYOPADHYAN) 20 April 1993

GB, 2255738, A (FRY'S METALS LIMITED) 18 November 1992

US, 4638849, A (WHITEHORN) 27 January 1987

None of the above cited patents, alone or in combination, render the claims not novel or un inventive.

# PATENT COOPERATION TREATY

From the:  
INTERNATIONAL PRELIMINARY EXAMINING AUTHORITY

To:

PAUL A GRANT  
PO Box 60  
FISHER ACT 2611

## PCT NOTIFICATION OF TRANSMITTAL OF INTERNATIONAL PRELIMINARY EXAMINATION REPORT

(PCT Rule 71.1)

Date of mailing  
day/month/year

-9 FEB 2001

Applicant's or agent's file reference

### IMPORTANT NOTIFICATION

International Application No.

PCT/AU00/01002

International Filing Date

24 August 2000

Priority Date

16 September 1999

Applicant

HOTFLO DIECASTING PTY LTD et al

1. The applicant is hereby notified that this International Preliminary Examining Authority transmits herewith the international preliminary examination report and its annexes, if any, established on the international application.
2. A copy of the report and its annexes, if any, is being transmitted to the International Bureau for communication to all the elected Offices.
3. Where required by any of the elected Offices, the International Bureau will prepare an English translation of the report (but not of any annexes) and will transmit such translations to those Offices.

#### 4. REMINDER

The applicant must enter the national phase before each elected Office by performing certain acts (filing translations and paying national fees) within 30 months from the priority date (or later in some Offices)(Article 39(1))(see also the reminder sent by the International Bureau with Form PCT/IB/301).

Where a translation of the international application must be furnished to an elected Office, that translation must contain a translation of any annexes to the international preliminary examination report. It is the applicant's responsibility to prepare and furnish such translation directly to each elected Office concerned.

For further details on the applicable time limits and requirements of the elected Offices, see Volume II of the PCT Applicant's Guide

Name and mailing address of the IPEA/AU

AUSTRALIAN PATENT OFFICE  
PO BOX 200, WODEN ACT 2606, AUSTRALIA  
E-mail address: pct@ipaustalia.gov.au  
Facsimile No. (02) 6285 3929

Authorized officer



A. Davies

Telephone No. (02) 6283 2072



# PATENT COOPERATION TREATY

## PCT

### INTERNATIONAL SEARCH REPORT

(PCT Article 18 and Rules 43 and 44)

Applicant's or agent's file reference	<b>FOR FURTHER ACTION</b> see Notification of Transmittal of International Search Report (Form PCT/ISA/220) as well as, where applicable, item 5 below.	
International application No. <b>PCT/AU 00/01002</b>	International filing date ( <i>day/month/year</i> ) <b>24 August 2000</b>	(Earliest) Priority Date ( <i>day/month/year</i> ) <b>16 September 1999</b>
Applicant 1. <b>HOTFLO DIECASTING PTY LTD et al</b>		

This international search report has been prepared by this International Searching Authority and is transmitted to the applicant according to Article 18. A copy is being transmitted to the International Bureau.

This international search report consists of a total of **4** sheets.

☒ It is also accompanied by a copy of each prior art document cited in this report.

**1. Basis of the report**

a. With regard to the **language**, the international search was carried out on the basis of the international application in the language in which it was filed, unless otherwise indicated under this item.

☐ the international search was carried out on the basis of a translation of the international application furnished to this Authority (Rule 23.1(b)).

b. With regard to any **nucleotide and/or amino acid sequence** disclosed in the international application, the international application, the international search was carried out on the basis of the sequence listing:

☐ contained in the international application in written form.

☐ filed together with the international application in computer readable form.

☐ furnished subsequently to this Authority in written form.

☐ furnished subsequently to this Authority in computer readable form.

☐ the statement that the subsequently furnished written sequence listing does not go beyond the disclosure in the international application as filed has been furnished.

☐ the statement that the information recorded in computer readable form is identical to the written sequence listing has been furnished

2. ☐ **Certain claims were found unsearchable** (See Box I).

3. ☐ **Unity of invention is lacking** (See Box II).

4. With regard to the **title**, ☒ the text is approved as submitted by the applicant.

☐ the text has been established by this Authority to read as follows:

5. With regard to the **abstract**, ☒ the text is approved as submitted by the applicant

☐ the text has been established, according to Rule 38.2(b), by this Authority as it appears in Box III. The applicant may, within one month from the date of mailing of this international search report, submit comments to this Authority.


6. The figure of the **drawings** to be published with the abstract is Figure No. **3**

☒ as suggested by the applicant.

☐ None of the figures

☐ because the applicant failed to suggest a figure

☐ because this figure better characterizes the invention

<b>A. CLASSIFICATION OF SUBJECT MATTER</b>					
Int Cl <sup>7</sup> : B22D 17/02, 17/30, 35/04, 35/06					
According to International Patent Classification (IPC) or to both national classification and IPC					
<b>B. FIELDS SEARCHED</b>					
Minimum documentation searched (classification system followed by classification symbols) IPC AS ABOVE + KEYWORDS					
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched AU: B22D 17/02, 17/30, 35/04, 35/06					
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) Derwent: heat+ and(runner or sprue)					
<b>C. DOCUMENTS CONSIDERED TO BE RELEVANT</b>					
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.			
A	US, 5 315 686, A (CAUGHERTY et al) 24 May 1994	1-20			
A	US, 5 203 397, A (BANDYOPADHYAN) 20 April 1993	1-20			
A	GB, 2 255 738, A (FRY'S METALS LIMITED) 18 November 1992	1-20			
<input checked="" type="checkbox"/> Further documents are listed in the continuation of Box C <span style="float: right;"><input checked="" type="checkbox"/> See patent family annex</span>					
<table style="width: 100%; border: none;"> <tr> <td style="width: 33%; vertical-align: top;"> <p>* Special categories of cited documents:</p> <p>"A" Document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier application or patent but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> </td> <td style="width: 33%; vertical-align: top;"> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art</p> <p>"&amp;" document member of the same patent family</p> </td> <td style="width: 33%;"></td> </tr> </table>			<p>* Special categories of cited documents:</p> <p>"A" Document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier application or patent but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p>	<p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art</p> <p>"&amp;" document member of the same patent family</p>	
<p>* Special categories of cited documents:</p> <p>"A" Document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier application or patent but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p>	<p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art</p> <p>"&amp;" document member of the same patent family</p>				
Date of the actual completion of the international search 20 September 2000		Date of mailing of the international search report 29 SEP 2000			
Name and mailing address of the ISA/AU AUSTRALIAN PATENT OFFICE PO BOX 200 WODEN ACT 2606 AUSTRALIA E-mail address: pct@ipaaustralia.gov.au Facsimile No.: (02) 6285 3929		Authorized officer  A. DAVIES Telephone No.: (02) 6283 2072			

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US, 4 638 849, A (WHITEHORN) 27 January 1987	1-20

### Information on patent family members

International application No.

**PCT/AU 00/01002**

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Patent Document Cited in Search Report		Patent Family Member					
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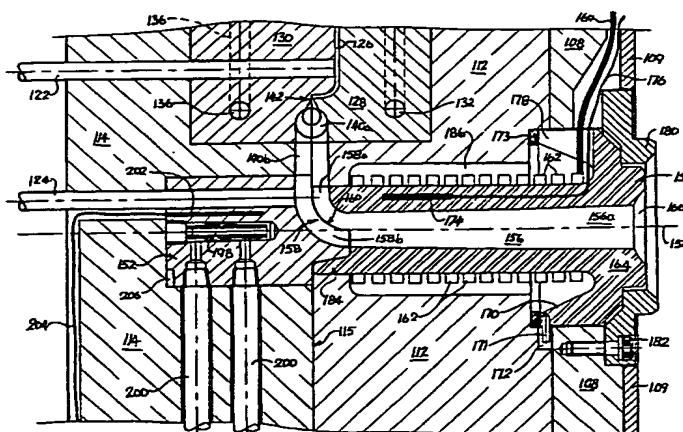
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(54) Title: HOT SPRUE SYSTEM FOR DIECASTING



(57) Abstract: Die inserts and methods for use in high-pressure hot-chamber diecasting are disclosed which substantially eliminate sprue castings and greatly improve melt flow. The die inserts comprise (i) a heated sprue body insert (130, 258) adapted for location in the fixed dieblock (112) of a die set and having a sprue channel (136, 260) and (ii) a cooled sprue tip insert (132, 266) adapted mounting in the moving dieblock (114) of the die set. The sprue body and tip inserts are mounted coaxially so that their inner ends mate with one another in the region of the die parting-line (155) to conjointly form at least one curved transition channel (138, 262, 264) that connects the sprue channel (136, 260) with at least one runner channel (140, 254, 256) formed along the parting-line. The temperatures of the sprue body insert and the sprue tip insert are controlled so that the freeze-point occurs in the transition channel and the melt in the sprue channel is able to run back into the machine nozzle at the end each shot, thereby eliminating sprue castings.

**TITLE:** HOT SPRUE SYSTEM FOR DIECASTING

## **TECHNICAL FIELD**

This invention relates to high-pressure diecasting methods and apparatus, and  
5 more particularly, to hot sprue systems for use with hot-chamber, high-pressure diecasting.

## **BACKGROUND TO THE INVENTION**

There is a very large installed base of hot-chamber, high-pressure, diecasting  
10 machines dedicated to the production of small die-cast products of zinc, lead, tin magnesium, aluminum and their alloys. Figure 1 shows a typical machine 10 of this type. A pool of molten metal 12 is held in a heated pot 14 from which 'shots' of melt are forced, by a plunger 16 working in a submerged cylinder 18, through a gooseneck 20 and an externally flame-heated connecting nozzle 22, into a cavity  
15 24 formed between a fixed die 26 and a moving die 28. Fixed die 26 is mounted on a fixed platen 30 and moving die 28 is mounted on a moving platen 32 that is pressed toward the fixed platen by the piston 34 of a hydraulic or pneumatic ram, the clamping force being taken by tie-rods 36. When dies 26 and 28 are closed, plunger 16 is driven downwards into cylinder 18 by the piston 38 of a pneumatic  
20 ram 40 to force a shot of melt into cavity 24 and to hold the pressure until it has frozen. After which, plunger 16 is raised to suck the remaining liquid melt from nozzle 22 and gooseneck 20 back into melt pool 12. To assist the flow-back of melt at the end of a shot, nozzle 22 normally slopes upward to fixed die 26. Indeed, for the same purpose, the whole press portion of the machine (comprising  
25 the dies and platens) can be tilted slightly downward towards nozzle 22.

At the commencement of a shot, the melt is conveyed from heated nozzle 22 through a sprue bush 42 fitted in the back of fixed die 26 and through a sprue channel 44, formed in the fixed die 26, to the interface or parting-line 46 of dies 26  
30 and 28. It is then conveyed along the interface 46 by one or more runner channels 48, through a gate orifice 49, into cavity 24. As the injection pressure in such machines is commonly between 10 and 30 mPa, nozzle 22 must be pressed hard against sprue bush 42 and gooseneck 20 to avoid leakage. The use of sprue bush

42 assists in forming the seal at the die end of nozzle 22 and it has the advantage that it can be easily replaced should a freeze-plug form therein after a shot.

Sprue channel 44 is strongly tapered so that it widens toward die interface 46 from sprue bush 42 in the direction of melt flow. It is of such a volume that the freeze-point will occur in sprue channel 44 inwards or down-stream of bush 42 at the end of a shot. On the other hand, the runner channel(s) generally narrow(s) in the direction of melt flow (i.e., towards gate 49) so that the melt is accelerated and enters the cavity at high velocity. This common arrangement of sprue and runner channels allows the cast sprue and runner(s) to be easily removed from the dies, together with the attached products, as one piece after the dies have opened. Each runner channel 48 is normally connected to its respective cavity 24 via narrow slot-like gate 49 so as to form a thin and easily broken connection between the product casting and it's attached runner and sprue castings.

It will be appreciated from the above that, in this specification, the sprue and runner channels form a melt path within the dies that conveys the melt to the cavity gate(s). The sprue channel conveys the melt from the exterior (normally the back) of the fixed die to the front face – or parting-line – of the fixed-die, while each runner conveys the melt from the sprue channel to the respective cavity gate along the interface between the fixed and moving dies. The sprue and runner castings are the die-cast metal that solidifies in the sprue and runner channels (respectively) at the end of a shot.

Though hot-chamber diecasting is very common, relatively trouble-free and can produce high quality product at high production rates, a major disadvantage of the technique is the large amount of metal contained in the sprue and runner castings compared with the metal in the product. After detachment from the products, the sprue and runner castings are generally remelted and reused, but this represents high-energy losses and causes melt contamination. Another significant disadvantage of conventional hot-chamber diecasting is the abrupt discontinuity in both section and direction in the melt path between the wide and widening sprue channel and the narrow and narrowing runner channel(s); a discontinuity which leads to turbulent and inefficient melt flow.

It will be appreciated that hot-chamber diecasting is a similar process to the injection moulding of plastics materials. While both can pump shots of melt into cavities via sprue and runner systems, losses associated with the sprue and runner castings are much less with injection moulding. In injection moulding, it is common to employ electrically heated sprue-channels (often called 'nozzles' in the injection moulding context), or electrically heated cores (called 'hot-tips') within the sprue-channels, to eliminate the generation of sprues. Indeed, if such a device is used to inject molten plastic directly into a cavity, both runners and sprues can be eliminated. It is even possible to use a mechanical valve in the sprue nozzle or hot-tip to close the channel at the entrance to the cavity so that the molten plastic feed-line can be kept pressurized between shots, allowing very high production rates.

While it has been suggested from time to time (see for example US patents 4,304,544 and 4,795,126 to Crandell) that heated nozzles and hot-tips designed for injection moulding can be used for direct-injection diecasting, this has proved impractical. The much higher melting point, thermal conductivity and electrical conductivity of metals relative to plastics have made direct-injection diecasting problematic.

The most notable attempt at direct-injection in hot-chamber diecasting known to the applicant is that undertaken by the Battelle Columbus Laboratories for the International Lead Zinc Research Organization [ILZRO] during most of the 1980s. A large number of progress reports were prepared and published on this work by ILZRO or Battelle. An early such report was published in a paper (No. G-T83-066) entitled "Heated Manifold, Direct-Injection System for Zinc Diecasting" by Groeneveld and Kaiser of Battelle and Herrschaft of ILZRO at the International Diecasting Congress and Exposition, Minneapolis, October 31 to November 3, 1983. A further progress report, entitled "Commercial Application of the Heated-Manifold Direct-Injection System of Zinc Diecasting" was published in a paper at the Exposition of June 3-6 1985 in Milwaukee, WI, with Groeneveld of Battelle as primary author. A further progress report (No. 30) on the ILZRO direct-injection project (authored by Groeneveld) was published by in March 1988, noting that



"several million castings have been made by direct injection". Production rates and product quality were reported to be at least equal to conventional diecasting using runners and sprues.

5 Despite the obvious and great benefits offered by direct-injection diecasting, the technique disclosed in the above publications (particularly, the Battelle work) has not been widely applied by the diecasting industry. The principal reason for this appears to be that die and 'nozzle' design methods for direct injection have not been developed to anywhere near the same facility and reliability as die, runner  
10 and sprue design techniques for conventional hot-chamber diecasting. Consequently, a great deal of highly-expert and highly-expensive experimentation must be undertaken before any given product, cavity, die, machine and 'nozzle' combination can be made to work satisfactorily. Furthermore, direct-injection in multi-cavity dies involves major changes to existing diecasting machines with  
15 respect to metal flow and control, making machine set-up and tool-changing lengthy processes. In short, implementation of direct-injection diecasting appears to be beyond the technical ability as well as the financial capacity of the great majority of hot-chamber die-casters.

## 20 **OUTLINE OF INVENTION**

The present invention is based upon the realization that a significant part of the benefit offered by direct-injection diecasting can be achieved with very little change to current die design and no change to hot-chamber machine layout, if a heated sprue channel is employed with a substantially conventional runner  
25 channel and if a curved transition channel connects the sprue channel to the runner channel. The temperature of the sprue channel can be controlled to ensure that the melt can run back from the sprue channel after each shot, while the temperature of the transition channel can be arranged so that the freeze-point occurs therein. If the die parting-line includes the transition channel, the casting  
30 formed therein (integral with the runner casting) can be ejected with the runner casting in the normal manner. The use of separate mating die inserts to define the transition channel enables the temperature of that channel to be controlled independently of the sprue insert and die temperature. One of the die inserts is

preferably a heated sprue body insert in the fixed die, while the other is preferably an opposing, mating and cooled sprue tip insert in the moving die.

Such a 'sprueless' diecasting technique can avoid the production, recovery and remelting of sprues (and so achieve most of the savings of direct-injection) with minimal change to die design, no change to machine layout and without any need for troublesome valved injection nozzles. Furthermore, the use of a hot-sprue die-insert allows the melt flow-path within the die to be optimized for streamlined flow without the need for any abrupt change of section. Indeed, gradual and uniform tapering of the melt path is readily achieved from the sprue inlet to the gate so that the melt is constantly and smoothly accelerated. The need for a reverse taper on the sprue channel to permit withdrawal of a sprue casting is, of course, eliminated.

It will be normal for the sprue channel to extend roughly horizontally in the fixed die so as to be orthogonal to the die parting-line and the back of the fixed die (as is conventional) and for the transition channel to be a smooth curve that subtends an angle of about  $90^\circ$  from the sprue channel to the runner channel. However, the sprue and/or the die parting-line may be oriented so that the angle subtended by the curve of the transition channel is other than  $90^\circ$ , though this will be unusual. As already noted, the transition channel can be made to decrease (taper) in cross-section in a smooth and uniform manner so that the melt is accelerated as it flows around the curve to enter the runner channel.

It is preferable that the insert in the moving die that defines portion of the transition channel has its own cooling means (such as provision for coolant circulation) so that its temperature can be adjusted independently of the rest of the moving die so as to ensure that freeze-off occurs in the transition channel. For this purpose, it is desirable for the insert to include temperature sensor means so that automatic regulation can be effected. Similarly, it is desirable for the sprue-insert in the fixed die to include temperature sensor means so that it can be kept at a sufficiently high temperature to ensure flow-back of the melt after a shot.

It will be appreciated that mating die inserts like those required to define the transition channel are familiar to average diecasting toolmakers and that the setting of appropriate temperatures for the sprue and transition channels to achieve appropriate flow-back and freeze-off (respectively) are well within the competency of average machine operators. Apart from the need for the die inserts, tool design and machine operation normally will be unaffected by the method of the present invention. Normal cavity inserts and ejection mechanisms can be used. Where there is more than one cavity in a die-set branching or radiating transition channels can be formed in the inserts to connect the sprue channel to the various runner channels.

It will be seen that the present invention relates to diecasting methods, diecasting apparatus and to die-inserts for use in diecasting.

## 15 DESCRIPTION OF EXAMPLES

Having portrayed the nature of the present invention, two examples will now be described with reference to the accompanying drawings. However, those skilled in the art will appreciate that many variations and modifications can be made to the chosen examples without departing from the scope of the invention as defined by the following claims.

### Brief Description of the Drawings:

Figure 1 is a part-sectional elevation of a typical prior art hot-chamber diecasting machine.

Figure 2 is a diagrammatic sectional elevation of portion showing the die-set of a typical diecasting machine with sprue inserts formed in accordance with the first example of the present invention.

Figure 3 is an enlarged view of portion of Figure 2.

Figure 4. is an enlarged plan view of portion of the die set of Figure 2 taken on section line III-III of Figure 2.

Figure 5 is a perspective view of the sprue-body insert of Figures 2 and 4.

Figure 6 is a perspective view of the sprue-tip insert of Figures 2, 3 and 4.

Figure 7 is a sectional elevation of a die-set having a sprue and a sprue-tip  
5 insert formed so as to feed two opposed runner channels.

Figures 2 - 4 show portion of a conventional diecasting machine 100 in which the die-set 102 is shown closed and mounted between a fixed platen 104 and a moving platen 106. Die-set 102 comprises a fixed backplate 108 secured to fixed  
10 platen 104 (with an insulating plate 109 placed there between) and a moving backplate 110 fixed to moving platen 106. A fixed dieblock 112 is secured to fixed backplate 108 and a moving dieblock 114 is secured to moving backplate 110. The interface or parting plane between dieblocks 112 and 114 is shown at 115. A bolster 116 is secured to each side of moving backplate 110 so as to transfer the  
15 force of moving platen 106 to moving dieblock 114 around an ejector assembly 118, which comprises a pair of ejector plates 120a and 120b that capture the heads of a set of four product ejector pins 122 and a single runner ejection pin 124.

20 A mould cavity 126 is formed between the faces of a fixed cavity insert 128 located in fixed dieblock 112 and a moving cavity insert 130 located in moving dieblock 114. Fixed cavity insert 128 has a cooling passage 132 (shown in broken lines) connected to fluid couplings 134 in dieblock 112 and moving cavity insert 130 has a cooling passage 136 (shown in broken lines) connected to fluid  
25 couplings 138 in dieblock 114. Runner channels 140a are formed between die inserts 128 and 130 connecting to a runner channel 140b formed between dieblocks 112 and 114, runner channels 140a being connected to cavity 126 by one or more gates 142. With the die set closed (as shown in Figures 2 and 4) a shot of melt is injected along runner channels 140 into mould cavity 126 to form  
30 product and runner castings. Moving platen 106, backplate 110, bolsters 116, dieblock 114 and die insert 130 are then withdrawn from the fixed portion of the die set while ejector assembly 118 is held stationary. Dieblock 114 therefore slides along pins 122 and 124 to effect the ejection of the product and associated runner castings formed in cavity 126 and runner channels 140.

As so far as described, die set 102 is quite conventional and typical of those widely employed in the hot-chamber diecasting industry.

5 The hot sprue system of the first example will now be described with particular reference to the enlarged sectional elevation of Figure 3 and the enlarged plan view of Figure 4. It comprises a cylindrical tubular sprue body insert 150 mounted in fixed backplate 108 and dieblock 122 and an opposed mating cylindrical sprue tip insert 152 mounted in moving dieblock 114, the inserts 150 and 152 being  
10 coaxial and their common axis 154 being orthogonal to interface 115. Sprue body insert 150 has a central tapering sprue channel 156 that narrows in section from its outer end 156a to its inner end 156b. The inner ends of inserts 150 and 152 mate near parting-line 115 to define a curved transition channel 158 that subtends an angle of  $90^\circ$  and connects sprue channel 156 to runner channels 140, the  
15 parting-line of transition channel 158 being indicated at 160. Both the transition channel 158 and runner channels 140 preferably narrow gradually toward gates 142.

Sprue body insert 150 has a cylindrical exterior about which is wound an electrical  
20 heating element 162 that can be supplied with electrical power via a lead 164. Body insert 150 has a mushroom-like head 164 that provides an outer recess 166, which forms a socket for the heated nozzle 168 (Figure 2) of diecasting machine 100, and an inner skirt 170 by which insert 150 is located in fixed dieblock 112. A pin 171 which extends radially from skirt 170 and locates in a groove 172 in fixed  
25 dieblock 112, and a ring shim 173 which spaces insert from dieblock 112, ensure that the inner end of body insert 150 mates properly with the inner end of tip insert 152 along parting-line 160. A thermocouple temperature sensor 174 is imbedded in body insert 150 and connected via lead 176 to suitable temperature measurement and control equipment (not shown). Heating element lead 164 and  
30 sensor lead 176 pass through a slot 178 formed in skirt 170 (see also Figure 5). Body insert 150 is held in place by a clamping ring 180 that is secured by bolts 182 to fixed backplate 108, the inner end 184 of insert 150 being a snug fit in dieblock 112 so that there is no leakage of melt from transition channel 158 into the space 186 in dieblock 112 that houses sprue insert 150.

With particular reference to Figure 5 (which does not show electrical heating element 162 or leads 164 and 176), the inner end 184 of body insert 150 has a part conical socket 190, in one side of which one half – indicated at 158a – of curved transition channel 158 (Figure 4) is formed. A convex-curved shoulder 192 is formed on each side of half channel 158a between it and the inner wall of socket 184.

With reference to Figures 3, 4 and 6, sprue tip insert 152 has a part conical plug 194 on its inner end that is shaped to fit snugly into socket 192 of body insert 150. One side of plug 194 is cut away to form a pair of concave-curved shoulders 196 on either side of curved groove 158b that forms half of transition channel 158. Shoulders 196 abut with the complementary shoulders 192 on sprue body insert 150. A central baffled cooling passage 198 is formed in insert 152 that connects to cooling fluid passages 200 formed in moving dieblock 114. A temperature sensor 202 is imbedded in insert 152 and its leads 204 are taken through dieblock 114 to a temperature controller (not shown) that regulates the flow of cooling fluid through passages 198 and 202. Finally, sprue tip insert 152 is rotationally located within its socket in dieblock 114 by the use of a key 206 (Figure 4). [The temperature sensor leads and cooling passages are not shown in Figure 6.]

Once sprue inserts 150 and 152 have been fitted into their respective dieblocks, the diecasting machine 100 is used in the conventional manner described above, except that the temperatures of the sprue inserts are adjusted to ensure that, at the end of each shot, (i) the melt in the sprue channel 156 remains sufficiently fluid to quickly drain back into nozzle 168 and (ii) the runner freeze-point occurs in transition channel 158. As the moving components of die set 102 are withdrawn from the fixed components after each shot, the product is ejected from cavity 126 by ejector pins 122 and the runner and transition castings are ejected from the runner and transition channels 140 and 158 with the assistance of ejector pin 124.

The second example of a hot sprue system formed in accordance with the present invention is shown in Figure 7. As in the first example, the die set includes a fixed back plate 108, thermal insulating plate 109, fixed dieblock 112 and moving

dieblock 114. In this example, however, two pairs of die inserts 250 and 252 are employed, fed by respective runner channels 254 and 256. The sprue body insert 258 in this example defines a central tapering sprue channel 260, as before. It is formed, located and clamped as in the first example, except that its inner end is bifurcated to form a pair of opposed curved half transition channels 262 and 264 that connect with respective runner channels 254 and 256. Similarly, the inner end of sprue tip insert 266 is bifurcated to form two opposed curved half transition channels 268 and 270 that connect with runners 254 and 256, mating with the corresponding half transition channels 262 and 264 of sprue body insert 258. As before, body insert 258 has a heating element 272 and tip insert 266 has a cooling passage 274. However, in this example, two ejector pins 276 and 278 are used to ensure that the casting formed in each transition channel is positively ejected when the dies part after each shot.

It will be appreciated from the above description that this sprue-less diecasting method can be easily introduced and operated with standard hot-chamber diecasting machines using only the normal skills of a tool-maker or machine-setter/operator. Only the simplest of adjustment and set-up procedures are required from a machine-setter. Yet, the economies and benefits of sprue-less diecasting are substantial.

However, as previously indicated, many variations and changes can be effected without departing from the scope of the present invention. Though considered advantageous, it is not essential to taper the sprue and transition channels as described in these examples. Satisfactory results can be obtained using non-tapering channels. It will also be appreciated that there are many ways known in the art whereby the sprue inserts can be correctly mounted and positioned in their respective dieblocks. The methods disclosed in the examples may not suit all die sets or toolmaking techniques and can be readily varied. For example, shims may be used with the sprue tip insert rather than – or in addition to – the sprue body insert in order to effect adjustment. Or, given appropriate machining in the first place, no shimming may be needed. Similarly, the method chosen to fit and clamp the sprue body in place may also be varied as convenient. It is envisaged that thermal insulating material can be formed around the heating element of the sprue

body to minimize heat loss to the fixed dieblock. Indeed, the sprue tip insert may also be insulated to minimize heat gain from the moving dieblock. Alternatively, the sprue tip insert need not be insulated or temperature controlled as the temperature the moving dieblock can be such as to hold the tip insert at a

5 temperature which ensures freeze-off in the transition channel.

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## CLAIMS

- 1 A hot-chamber high-pressure diecasting method employing a fixed die, a  
movable die, a mould cavity formed between the fixed and movable dies, and a  
5 melt path comprising (i) a sprue channel formed in the fixed die for conveying  
molten diecasting metal from the hot chamber into the die, (ii) a runner channel  
formed between the fixed and moving dies at an angle to the sprue channel for  
conveying molten metal from the sprue channel into the mould cavity via a gate  
that is also formed between the fixed and movable dies, and (iii) a curved  
10 transition channel for conveying molten metal from the sprue channel to the  
runner channel through said angle; the method comprising the steps of:  
heating the sprue channel to a temperature that is higher than that of the  
dies and approximating the melting point of the diecasting metal,  
controlling the temperature of the dies so that they are below the melting  
15 point of the diecasting metal,  
injecting a shot of molten metal into the sprue channel, transition channel,  
runner channel and mould cavity,  
allowing molten diecasting metal remaining in the sprue channel to empty  
therefrom while allowing diecasting metal in the runner channel and in portion of  
20 the transition channel to solidify to form a runner and while allowing diecasting  
metal in the mould cavity to solidify to form a product,  
separating the movable die from the fixed die, and  
ejecting the product from the mould cavity together with the runner from the  
runner channel and portion of the transition channel.  
25
- 2 A hot-chamber, high-pressure diecasting method comprising the steps of:  
injecting a shot of molten diecasting metal through a gate into a mould  
cavity via a melt path comprising (i) a sprue channel formed in a fixed die and  
having an inlet opening in an exterior surface of said fixed die, (ii) a smoothly  
30 curved transition channel formed at least in part between said fixed die and a  
movable die that cooperates with the fixed die to form said cavity and said gate,  
and (iii) a runner channel formed between the fixed and movable dies, said runner  
channel extending between said transition channel and said gate,

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heating said sprue channel above the melting point of the diecasting metal while maintaining the temperature of the dies below said melting point,

allowing molten diecasting metal remaining in the sprue channel and in portion of the transition channel after the shot to flow back out of the inlet of the sprue channel,

allowing diecasting metal in the runner channel, portion of the transition channel, and in the gate and the mould cavity to solidify,

separating the movable die from the fixed die, and

ejecting the solidified metal from at least one of the dies.

10

3 A method according to claim 1 or 2 including the step of:

uniformly accelerating the molten diecasting metal as it flows along the melt path, the uniform acceleration of the diecasting metal being enabled by uniformly reducing the cross-sectional area of the channels of the melt path in the direction of flow.

15

4 A method according to any preceding claim including the step of conveying the shot of molten diecasting metal in a smooth curve through an angle of approximately  $90^{\circ}$  while it is within the transition channel.

20

5 A method according to any preceding claim wherein the transition channel is split so that a first part thereof is located by the fixed die and a second part thereof is located by the moving die, the method including the step of:

controlling the temperature of the second part of the transition channel independently of the temperature of the moving die so as to ensure that the freeze-point of the diecasting metal occurs within the transition channel after a shot.

25

6 A die-set for use in a hot-chamber, high-pressure diecasting process, comprising:

30

- a fixed die forming part of a mould cavity, part of a gate for admitting melt into the cavity and a runner channel for conveying melt to the gate, said fixed die having an exterior face,

14

- a movable die also forming part of said mould cavity, part of said gate and said runner channel,
- a sprue channel formed in the fixed die for conveying melt from the exterior face of the fixed die, the sprue channel being disposed at an angle to the runner channel,
- a curved transition channel formed between the fixed and the moving dies for conveying melt from the sprue channel through said angle to the runner channel when the dies are closed, and
- heater means associated with said sprue channel adapted to maintain the sprue channel near the melting point of the diecasting metal during operation of the die set.

7 A die set according to claim 6 wherein:

the sprue channel is formed by a first die insert that is fitted within the fixed die, said first insert having an outer end forming an inlet of the sprue channel on the exterior of the fixed die and said first insert having an inner end that forms a first part of the transition channel when the dies are closed, and

a second die insert is fitted in the moving die opposite the first insert, said second insert having an inner end which forms a second part of the of the transition channel when the dies are closed.

8 A die set according to claim 7 wherein:

said heater means comprises an electrical heating element formed around said first insert, and

cooling means are associated with the second insert adapted to cool said second part of the transition channel independently of said first die insert so that, in operation, the freeze-point of the diecasting metal can be made to occur within the transition channel.

9 A die set according to any one of claims 6 to 8 wherein the cross-sectional area of the sprue channel reduces uniformly in the direction of melt flow so that the velocity of the melt increases uniformly within the sprue channel during a shot.

15

10 A die set according to any one of claims 6 to 8 wherein the cross-sectional area of the portion of the melt path which comprises the sprue channel, the transition channel and the runner channel reduces uniformly in the direction of melt flow so that the velocity of the melt increases uniformly within said melt path.

5

11 A die set according to any one of claims 6 to 10 wherein said angle is substantially 90°.

12 A die set according to any one of claims 6 to 11 having an ejector pin  
10 slidably located within one of said dies for movement into the transition channel so as to be adapted to eject diecasting metal that solidifies within the transition channel after a shot and after separation of the movable and fixed dies.

13 A sprue insert-set for use in a high-pressure, hot-chamber diecasting  
15 apparatus having a fixed die and a moving die having respective parting faces that cooperate to define a runner channel, a gate and a cavity, the sprue insert-set comprising:

a tubular sprue body insert forming a sprue channel and adapted for mounting within the fixed die at an angle to the parting face of the fixed die, said  
20 body insert having an outer end defining an inlet to the sprue channel adapted for location at an external surface of the fixed die, and said sprue insert having an inner end defining an outlet adapted for location in the vicinity of the parting face of the fixed die when the sprue insert is mounted within the fixed die,

heating means associated with the body insert for heating the said insert,  
25 a first curved groove formed in the inner end of said body insert adapted to cooperate with a second curved groove associated with the moving die such that, when the body insert is mounted within the fixed die, said first and second grooves cooperate to form a curved transition channel connecting the outlet of the sprue channel to the runner channel when the dies are closed.

30

14 A sprue insert-set according to claim 13 wherein:

the sprue channel and the first curved groove are tapered uniformly in the direction of melt flow so that the velocity of the melt will increase uniformly as it

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travels from the outlet of the sprue channel to the runner channel when the insert-set is in use and the dies are closed.

15     A sprue insert-set according to claim 13 or 14 wherein said angle is  
5     substantially 90° and the first curved groove subtends substantially 90°.

16     A sprue insert-set according to any one of claims 13 to 15 wherein the  
sprue body insert includes temperature sensor means.

10    17     A sprue insert-set according to any one of claims 13 to 16 wherein the  
sprue body insert includes thermal insulation encompassing the heater means so  
as to mitigate the loss of heat from the sprue insert to the fixed die when the sprue  
insert-set is in use.

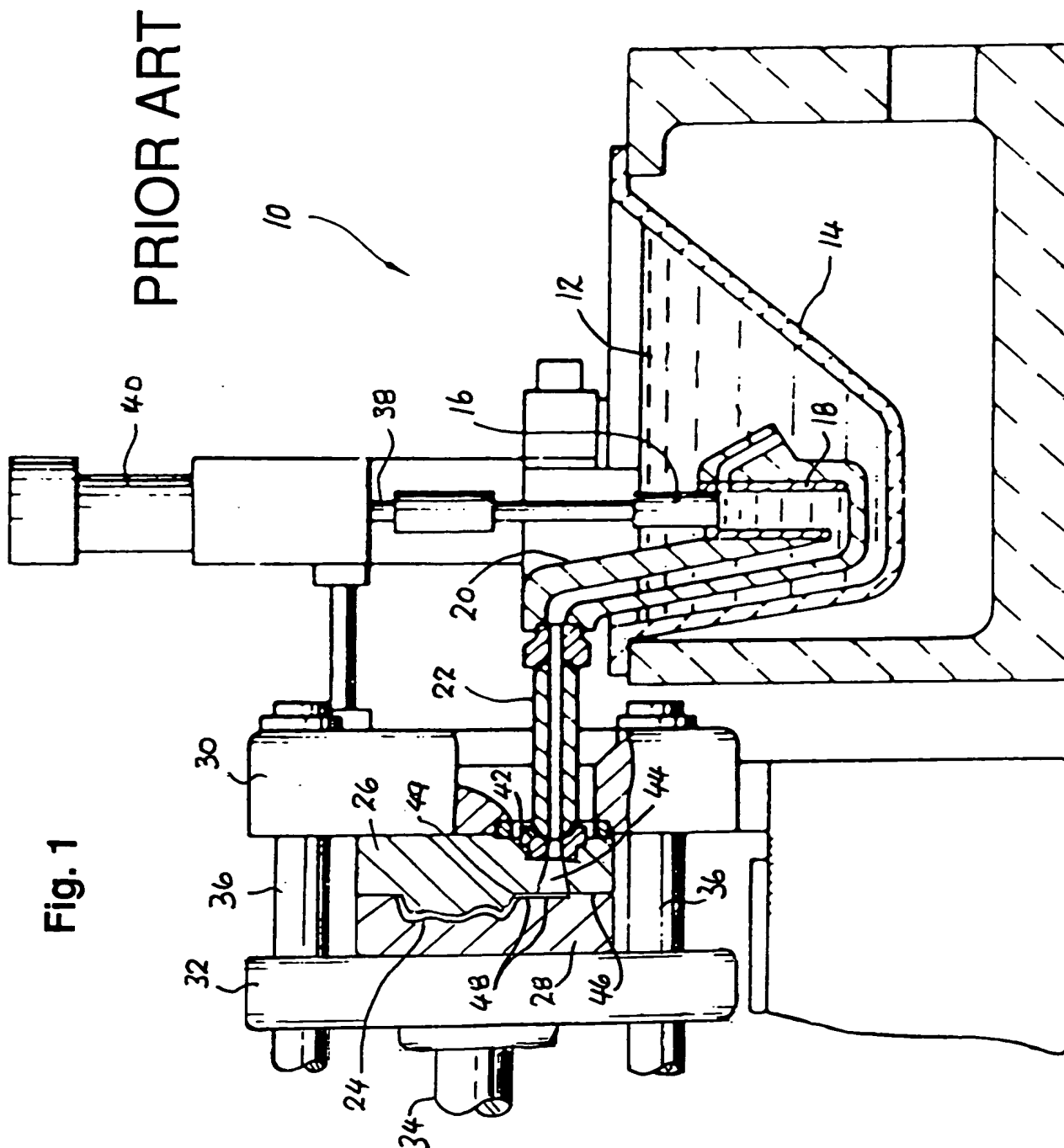
15    18     A sprue insert-set according to any one of claims 13 to 17 including:  
a sprue tip insert adapted for mounting within the moving die, said tip insert  
having an inner end forming said second curved groove.

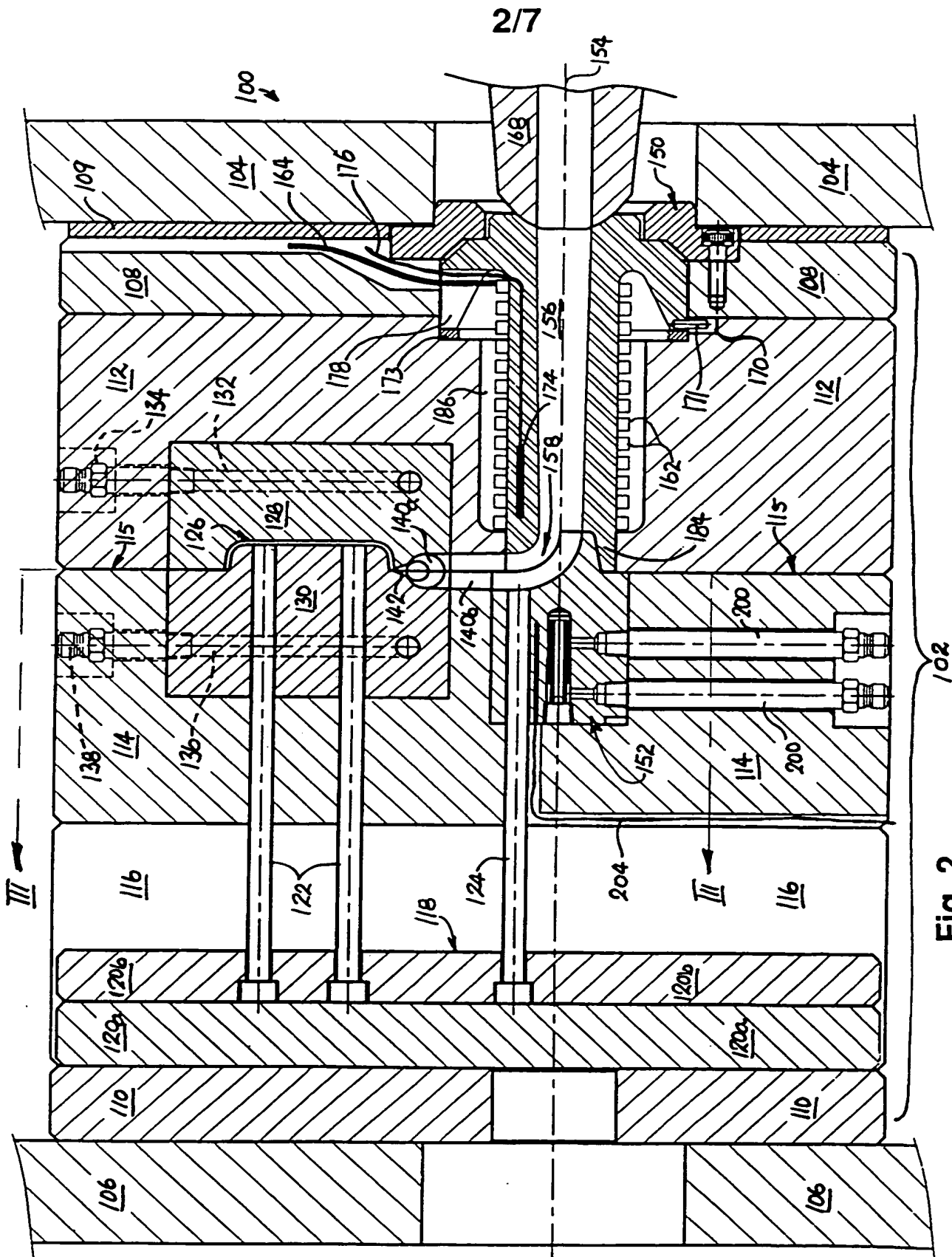
19     A sprue insert-set according to claim 18 wherein said tip insert includes  
20     cooling means associated with the tip insert whereby the tip insert may be held at  
a temperature below that of the sprue body insert when the insert-set is in use.

20     A sprue insert-set according to claim 18 or 19 wherein said tip insert  
includes temperature sensor means and thermal insulation adapted to mitigate  
25     thermal transfer between said second insert and the moving die.

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Fig. 1





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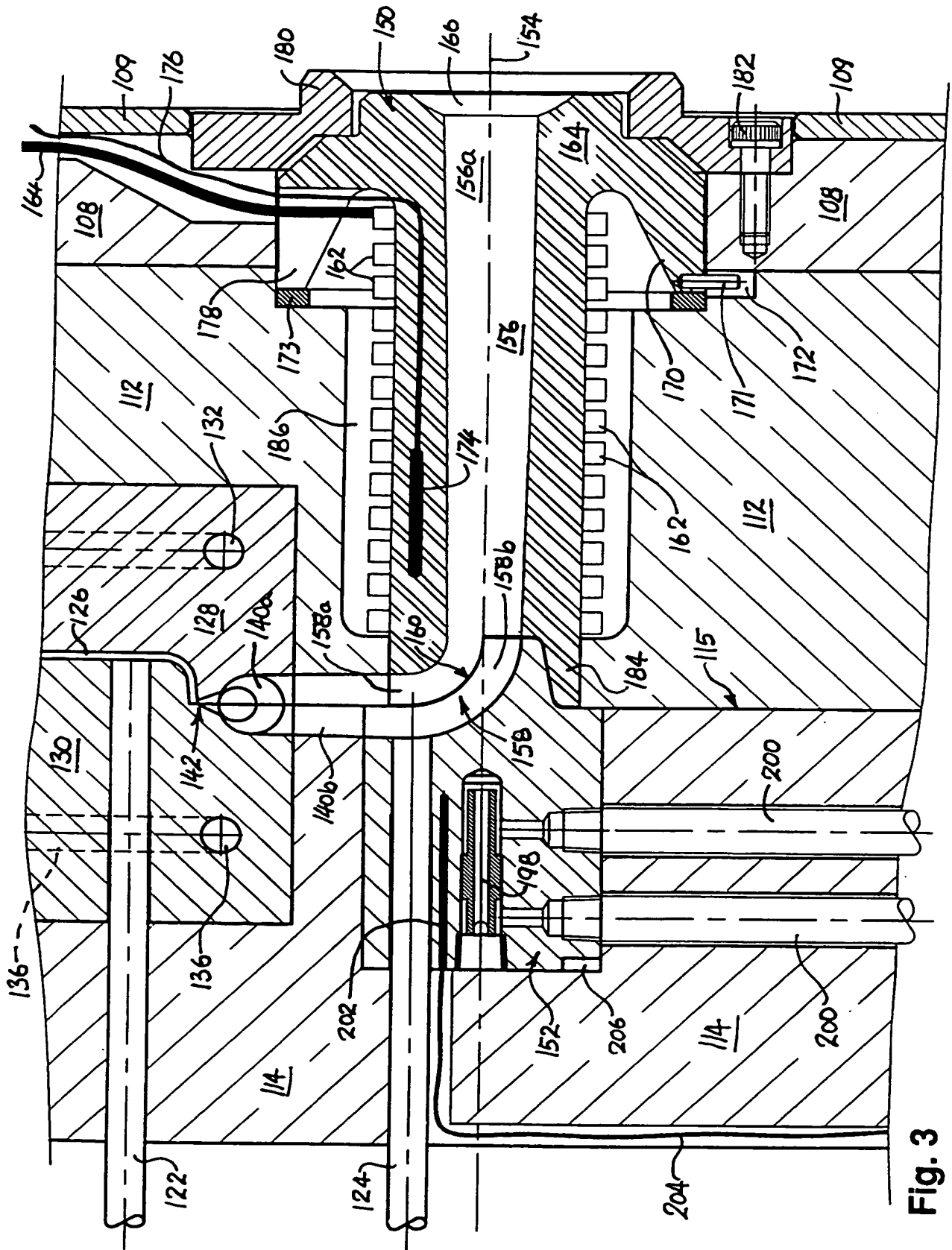
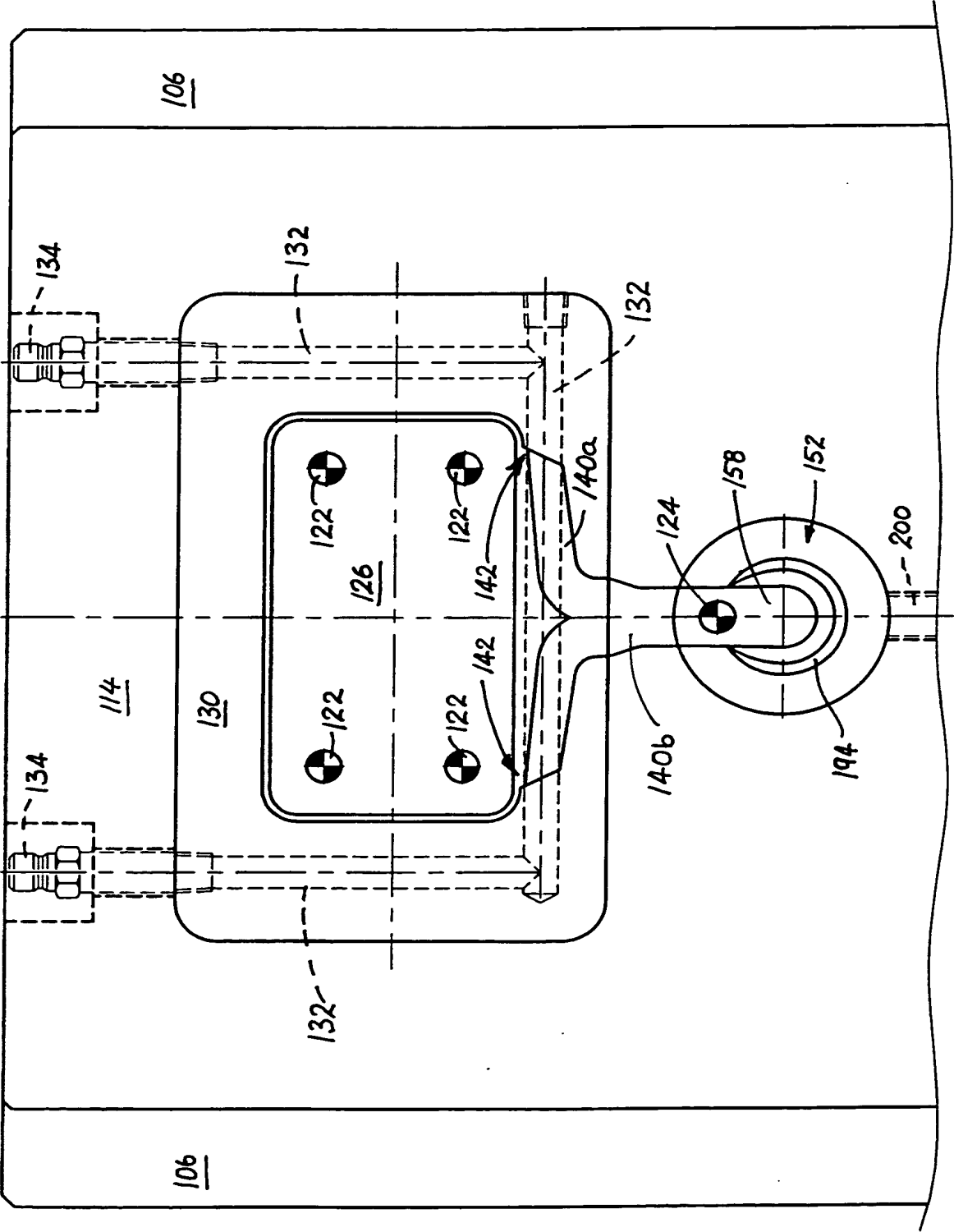


Fig. 3



Fig. 4



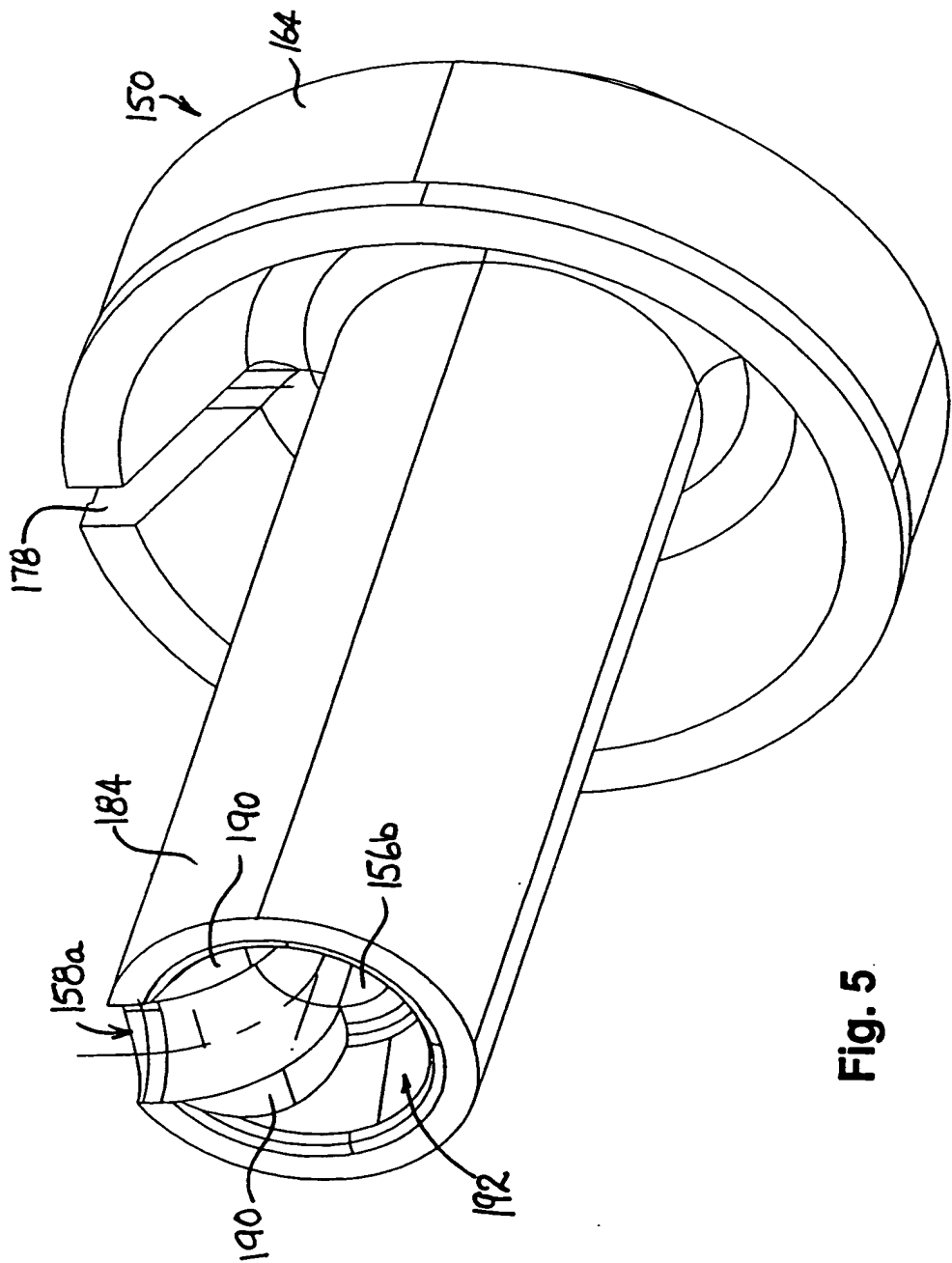


Fig. 5

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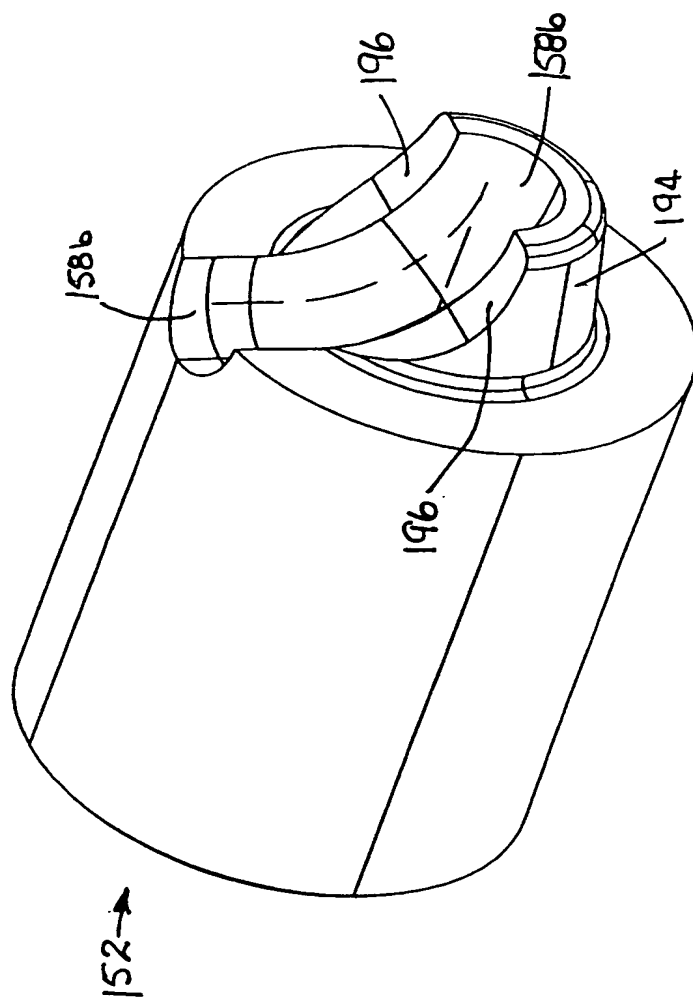


Fig. 6

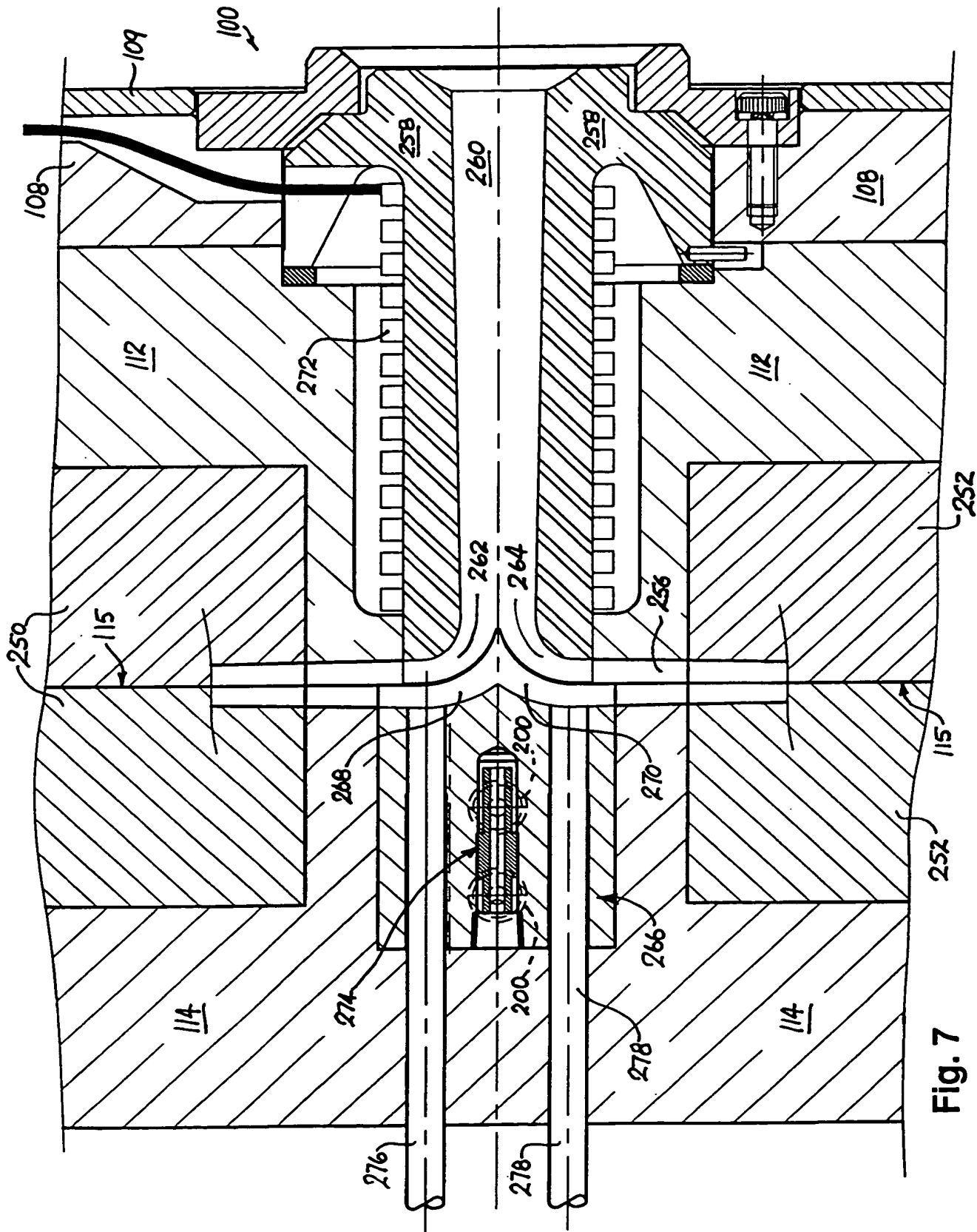



Fig. 7

## INTERNATIONAL SEARCH REPORT

 Internati nal applicati n N .  
 PCT/AU 00/01002

<b>A. CLASSIFICATION OF SUBJECT MATTER</b>		
Int Cl <sup>7</sup> : B22D 17/02, 17/30, 35/04, 35/06		
According to International Patent Classification (IPC) or to both national classification and IPC		
<b>B. FIELDS SEARCHED</b>		
Minimum documentation searched (classification system followed by classification symbols) IPC AS ABOVE + KEYWORDS		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched AU: B22D 17/02, 17/30, 35/04, 35/06		
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) Derwent: heat+ and(runner or sprue)		
<b>C. DOCUMENTS CONSIDERED TO BE RELEVANT</b>		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US, 5 315 686, A (CAUGHERTY et al) 24 May 1994	1-20
A	US, 5 203 397, A (BANDYOPADHYAN) 20 April 1993	1-20
A	GB, 2 255 738, A (FRY'S METALS LIMITED) 18 November 1992	1-20
<input checked="" type="checkbox"/> Further documents are listed in the continuation of Box C <input checked="" type="checkbox"/> See patent family annex		
* Special categories of cited documents: "A" Document defining the general state of the art which is not considered to be of particular relevance "E" earlier application or patent but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search 20 September 2000		Date of mailing of the international search report 29 SEP 2000
Name and mailing address of the ISA/AU AUSTRALIAN PATENT OFFICE PO BOX 200 WODEN ACT 2606 AUSTRALIA E-mail address: pct@ipaustalia.gov.au Facsimile No.: (02) 6285 3929		Authorized officer  A. DAVIES Telephone No.: (02) 6283 2072

## INTERNATIONAL SEARCH REPORT

International application No.  
PCT/AU 00/01002

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US, 4 638 849, A (WHITEHORN) 27 January 1987	1-20

International application No.  
PCT/AU 00/01002

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Patent Document Cited in Search Report		Patent Family Member					
US	5 315 686	US	5 448 678				
US	5 203 377	AU	54471/90	BR	9 006 407	CA	2 030 791
		EP	420 959	EP	550 417	JP	7 151 293
		SU	1 835 025	WO	9 012 243		
<div>END OF ANNEX</div>							